

Tennessee Department of Agriculture  
Consumer and Industry Services  
Ag Inputs

Anhydrous Ammonia Storage Facility Inspection Contract

Invitation to Bid Specifications

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**Invitation to Bid**

This Invitation to Bid is for the provision of annual Anhydrous Ammonia Storage Facility Inspection, as well as Anhydrous Ammonia Nurse Tank Inspection, and reporting of results and associated support. The provider shall be able to provide quality analysis for ten (10) anhydrous ammonia storage facilities and all nurse tanks located in the State of Tennessee. Storage facilities' addresses outlined in Attachment A.

**Background Information**

The State of Tennessee (hereinafter referred to as "State") intends to secure a provider (hereinafter referred to as "Contractor") to inspect anhydrous ammonia storage facilities and nurse tanks located in the State of Tennessee.

Contractor shall perform the inspection and reporting of the anhydrous ammonia storage facilities and nurse tanks. The inspection of nurse tanks will take place at the site of the anhydrous ammonia storage facilities. Additionally, Contractor will agree to appear and testify in court as required to support the compliance of Chapter 0080-5-7 Rules and Regulations Pertaining to Anhydrous Ammonia Storage & Equipment Act.

**Contract Term and Delivery Requirements**

Contract term will be for sixty (60) months. Contractor shall perform the inspection of all anhydrous ammonia storage facilities, nurse tanks, and associated equipment on an annual basis. The scope of the inspection is intended to apply to the design, construction, repair, alteration and operation of agricultural anhydrous ammonia systems.

The annual inspection schedule will be arranged in consultation with the Tennessee Department of Agriculture. Inspection is to assure compliance with Chapter 0080-5-7 Rules and Regulations Pertaining to Anhydrous Ammonia Storage & Equipment Act.

The annual inspection of anhydrous ammonia storage tanks shall include:

- Area free of weeds, trash & other unsafe conditions
- Anhydrous Ammonia Safety Equipment
- Emergency Sign
- Emergency Water or shower with plumbed eyewash unit
- ASME Data Plate
- Pressure Vessel suitable for anhydrous ammonia storage

- Free of leaks
- Inside or Outside the city limits
- Storage Tank appurtenances present & in good working condition
- All appurtenances, valves, fittings, hoses & plumbing approved for use with anhydrous ammonia
- Hydrostatic relief valve installed between two pairs of positive shut-off valves on a liquid line
- Manifold in working condition.
- Relief valves free of debris with rain caps installed & within 5 years from the date of manufacture
- Tank Supports in good condition (fiber pad in place)
- Tank free of rust or corrosion
- Valves equipped with locking devices
- Storage Tank labeled (Caution Ammonia or Caution Anhydrous Ammonia)
- Schedule 80 or 40 plumbing
- Plumbing supports & guards in place where necessary
- Piping free of rust or corrosion & properly painted
- Condition of nurse tank riser/structure

The annual inspection of anhydrous ammonia nurse tanks shall include:

- Minimum of 250 or 265 psig working pressure
- Nurse tanks that have non-legible data plates or data plates that are no longer affixed to the tank shall be enrolled into the Nurse Tank Inspection Program or removed from service (to be used as a means of educational outreach in order that the storage facilities can be trained on proper protocol regarding the placement and readability of the data plates)
- Free of leaks
- Tank free of rust or corrosion
- Valves & fittings free from leaks and in good condition
- Protective guards in place & in good condition
- Outlet openings on valves & lines free of dirt and rust with screw on protective caps in place
- Relief valves free of debris with rain caps installed & within 5 years from the date of manufacture
- Gauges – pressure & liquid level operative
- Valves labeled liquid or vapor
- Condition of ammonia hoses

- Hoses secured to a parking plug when not in use
- Tank securely attached, condition of trailer, tongue, tires & lugs
- Suitable safety chains permanently attached to the drawbars
- Tanks properly labeled (placarded)
- Slow Moving Vehicle (SMV) in place
- Five gallon or larger water container filled with clean water mounted on top or side of tank
- Hydrostatic relief valve installed between two pairs of positive shut-off valves on a liquid line
- Repair welding performed only on tanks with a legible data plate by an “R” stamp holder
- Maintenance records in place

**Anhydrous Ammonia Storage Facility Addresses**

Weakley Farmers CO-OP  
330 Nash Street  
Martin, TN 38237-0028

Crop Production Services, Inc.  
530 North 5th Street  
Union City, TN 38261

Obion Farmers CO-OP  
800 Mt. Zion Road  
Union City, TN 38281

Crop Production Services, Inc.  
6655 Highway 89  
Palmerston, TN 38241

Helm Fertilizer Terminal, Inc.  
1421 Channel Avenue  
Memphis, TN 38113

Bone Ammonia Service, Inc.  
5036 Roberts Creek Road  
Waverly, TN 37185

Crop Production Services, Inc.  
24413 US Highway 70 West  
Huntington, TN 38344

Weakley Farmers CO-OP  
2780 North Meridian Street  
Greenfield, TN 38230

Henry Farmers Cooperative  
1211 West Wood Street  
Paris, TN 38242

Robinson & Belew, Inc.  
240 Park Avenue  
Sharon, TN 38255